

Year	1970	1971	1972	1973	1974	1975	1976	1977	1978	1979	1980	1981	1982	1983	1984	1985	1986	1987	1988	1989	1990	1991	1992	1993	1994	1995	1996	1997	1998	1999	2000	2001	2002	2003	2004	2005	2006	2007	2008	2009	2010	2011	2012	2013	2014	2015	2016	2017	2018	2019	2020	2021	2022	2023	2024	2025	2026	2027	2028	2029	2030	2031	2032	2033	2034	2035	2036	2037	2038	2039	2040	2041	2042	2043	2044	2045	2046	2047	2048	2049	2050	2051	2052	2053	2054	2055	2056	2057	2058	2059	2060	2061	2062	2063	2064	2065	2066	2067	2068	2069	2070	2071	2072	2073	2074	2075	2076	2077	2078	2079	2080	2081	2082	2083	2084	2085	2086	2087	2088	2089	2090	2091	2092	2093	2094	2095	2096	2097	2098	2099	2100
1970	1971	1972	1973	1974	1975	1976	1977	1978	1979	1980	1981	1982	1983	1984	1985	1986	1987	1988	1989	1990	1991	1992	1993	1994	1995	1996	1997	1998	1999	2000	2001	2002	2003	2004	2005	2006	2007	2008	2009	2010	2011	2012	2013	2014	2015	2016	2017	2018	2019	2020	2021	2022	2023	2024	2025	2026	2027	2028	2029	2030	2031	2032	2033	2034	2035	2036	2037	2038	2039	2040	2041	2042	2043	2044	2045	2046	2047	2048	2049	2050	2051	2052	2053	2054	2055	2056	2057	2058	2059	2060	2061	2062	2063	2064	2065	2066	2067	2068	2069	2070	2071	2072	2073	2074	2075	2076	2077	2078	2079	2080	2081	2082	2083	2084	2085	2086	2087	2088	2089	2090	2091	2092	2093	2094	2095	2096	2097	2098	2099	2100	

1. A method for acceleration and deceleration control for supplying a movement command which has been subjected to acceleration and deceleration processing to a servo control section, wherein
acceleration in said acceleration and deceleration processing is determined such that a speed-acceleration curve of said movement command which has been subjected to acceleration and deceleration processing may lie along a predetermined speed-acceleration curve; and
said speed-acceleration curve is set for each axis and dependent on acceleration or deceleration.
2. The method for acceleration and deceleration control according to claim 1, wherein said speed-acceleration curve is set for each direction of movement.
3. The method for acceleration and deceleration control according to claim 1, wherein, in acceleration, an acceleration in said acceleration and deceleration processing is obtained so that it lies along said speed-acceleration curve, while, in deceleration, the processing is done with a fixed acceleration.
4. The method for acceleration and deceleration control according to claim 1, 2 or 3, wherein, in acceleration, an acceleration in said acceleration and deceleration processing is obtained so that it lies along said speed-acceleration curve,

while, in deceleration, the processing is done through filtering for a certain period of time with respect to the fixed acceleration.

5. A numerical control device, comprising:
 a memory for storing, for each control axis, the relation between individual speeds in acceleration and corresponding restricted accelerations and also the relation between individual speeds in deceleration and corresponding restricted decelerations, in the form of a table;

acceleration-deceleration determination means for determining as to whether or not an acceleration operation should be done, an operation of a command speed should be done or a deceleration operation should be done, for said axis, in the present processing cycle:

speed determination means for determining speeds in the present processing period, by using a speed in the present processing cycle as a command speed in the case where said acceleration-deceleration determination means decided that an operation of a command speed be applied, by reading from said memory a restricted acceleration corresponding to the speed of said axis obtained in the previous processing cycle to determine a speed in the present processing cycle using said restricted acceleration thus read in the case where said acceleration-deceleration determination means decided that

[illegible]

output means for finding data on the amount of movement of said axis in the present processing cycle by using the speed found by said speed determining means, and then outputting said data on the amount of movement to a servo control system for said axis.